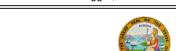
### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133

(707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

69.28 File #:

## WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-005719 Address: 333 Burma Road **Date Inspected:** 11-Mar-2009

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name:** N/A **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:** 

34-0006 **Bridge No: Component:** Deck panels

## **Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

This QA continued Phased Array Ultrasonic Testing (PAUT) training under the direction of NDT Professionals Inc. (NPI) representative Dave Johnson. Training was specific to crack detection on the Partial Joint Penetration (PJP) U-rib to deck panel welds.

#### Outside Deck Panel Repair Area

QA performed R2 Phased Array Ultrasonic Testing (PAUT) following the guide lines of UT procedure titled "Phased Array Ultrasonic Testing for the Detection and Sizing of Suspected Planar Discontinuities (Cracks) in PJP Welds" after ZPMC welding personnel performed R1 repairs in the tacked areas of the Partial Joint Penetration (PJP) welds joining u-ribs to deck plate. The deck panels examined are as follows: DP-088-001 (3 of 20 areas rejected), DP-493-001 (2 of 4 areas rejected).

NOTE: The following are the dbs reference levels obtained from known cracks in two macroetch samples:

2mm macroetch crack sample 5-9 DP-564: 21 dbs. 4mm macroetch crack sample 5-6 DP-564: 15.6 dbs.



# WELDING INSPECTION REPORT

(Continued Page 2 of 2)

# **Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

## **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer